

Work Order ID 130305

Friday, March 06, 2015 10:20:06 AM

130305

Page 1

Item ID: D3910-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug
 Start Date: 3/4/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/5/2015 Req'd Qty: 4.00 ***4*** Customer: CHELI21
 Reference: RMA RA111780

Approvals: Process Plan: MF Date: 15-3-6 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
100		0.00							
100									
QC	Memo	0.00							
Quality Control	INSPECT RA111780 D3910-5 X 4 B115197								
	OLD REV								
	SCRAP								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	SCRAP								
130		0.00							
130									
Control	QC21- Final Inspection Work Order Release								

DAG 9 9-89

④ 15-03-06

DAG 9 9-89

④ 15-03-06

④ 15-3-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 130305

130305

Parent Item: D3910-5

D3910-5

Parent Item Name: Crosstube Lug

Start Date: 3/4/2015

Required Date: 3/5/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
13.09.26 AS PER REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-5		Manufactured	No				Each	20.0000		4			

D3910-5

Crosstube Lug

Location

Loc Qty

Loc Code

ST525

20

117637

20

4 x 115/47 MF
15-3-6

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

RA111780 D3910-5

B115197 REV D

Received @ Dart February 23rd, 2015
Inspected@ Dart March 3rd, 2015

CUSTOMER: HELITEAM TEKNISK
CUSTOMER CONTACT: TORULF ANDERSSON
SHIPPED FROM: HARSTAD, NORWAY

Instructions for RA111780 D3910-5 B115197

- D3910-5 doesn't conformed with current drawing
- Scrap D3910-5 B115197 4x

Time Estimate = 1 hour
Departments Required: Quality
Pictures Attached = N/A
QTY INSPECTED = 4x D3910-5 B115197

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

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